

Date: Monday, 1/8/2007 10:50:35 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SUPPORT
Job Number : 30150B
Estimate Number : 10462
P.O. Number : *N/A* Part Number : D32782
This Issue : 1/8/2007 S.O. No. : *N/A* Drawing Number : D3278 REV. B
Prsht Rev. : NC Project Number : *N/A*
First Issue : *N/A* Type : SMALL /MED FAB Drawing Revision : B
Previous Run : 29647B Material : *N/A*
Due Date : 1/20/2007 Qty: 50 Um: Each
Written By : *[Signature]*
Checked & Approved By : *[Signature]* 07 01 08
Comment : Est:A 04.04.19 New issue: KJ/JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6B1000X02000

6061-T6 Bar 1.0" x 2.0"



Comment: Qty.: 0.2454 f(s)/Unit Total : 12.2693 f(s)
Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick
(M6061T6B1.000x02.000)

Batch:

*M19295/14PCS**M19059/36PCS**J.F. 07/01/14**(50)*

2.0

SHEAR

SHEAR



Comment: ~~CLIP~~ *Bawn Saw*
Cut blank: 2.00" x 1.00" x 2.550" long

*J.F. 07/01/14**(50)*

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
1- Machine as per Folio FA405 and Dwg D3278
2- Deburr and Tumble
Identify as D3278-2

*J.F. 07/01/15**(50)*

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.F. 07/01/15**(50)*

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*ml 07/01/14**50*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/01/19

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:50:36 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 30150B

Part Number: D32782

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SS/YL

07/01/17

(50)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

~~FC~~ FX/a.n

07/01/18

(50)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FC

07 01

B

(50)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/01/19 50

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/19

(50)

Job Completion



u 07/01/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	30150B
Description: Support		Part Number:	D3278-2
Inspection Dwg: D3278 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST



☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø.099	✓			
0.359	+/-0.005	.362"	✓			
0.6	+/-0.010	.616"	✓			
0.250	+/-0.010	.251"	✓			
1.480	+/-0.005	1.485"	✓			
R0.125	+/-0.010	R0.125"	✓			
0.119	+0.005/-0.004	.120"	✓			
2.439	+/-0.010	2.439"	✓			
1.980	+/-0.010	1.979	✓			
R0.130	+/-0.010	R0.130"	✓			
Ø0.257	+0.005/-0.000	Ø.259"	✓			
R0.375	+/-0.010	.376"	✓			
0.875	+/-0.010	.876"	✓			
0.500	+/-0.010	.500"	✓			
R0.400	+/-0.010	R.400"	✓			
1.720	+/-0.010	1.721"	✓			
R0.125	+/-0.010	R0.125	✓			
0.125	+/-0.010	.126"	✓			

Measured by: JF	Audited by: SD	Prototype Approval:	N/A
Date: 07/01/14	Date: 07.01.14	Date:	N/A

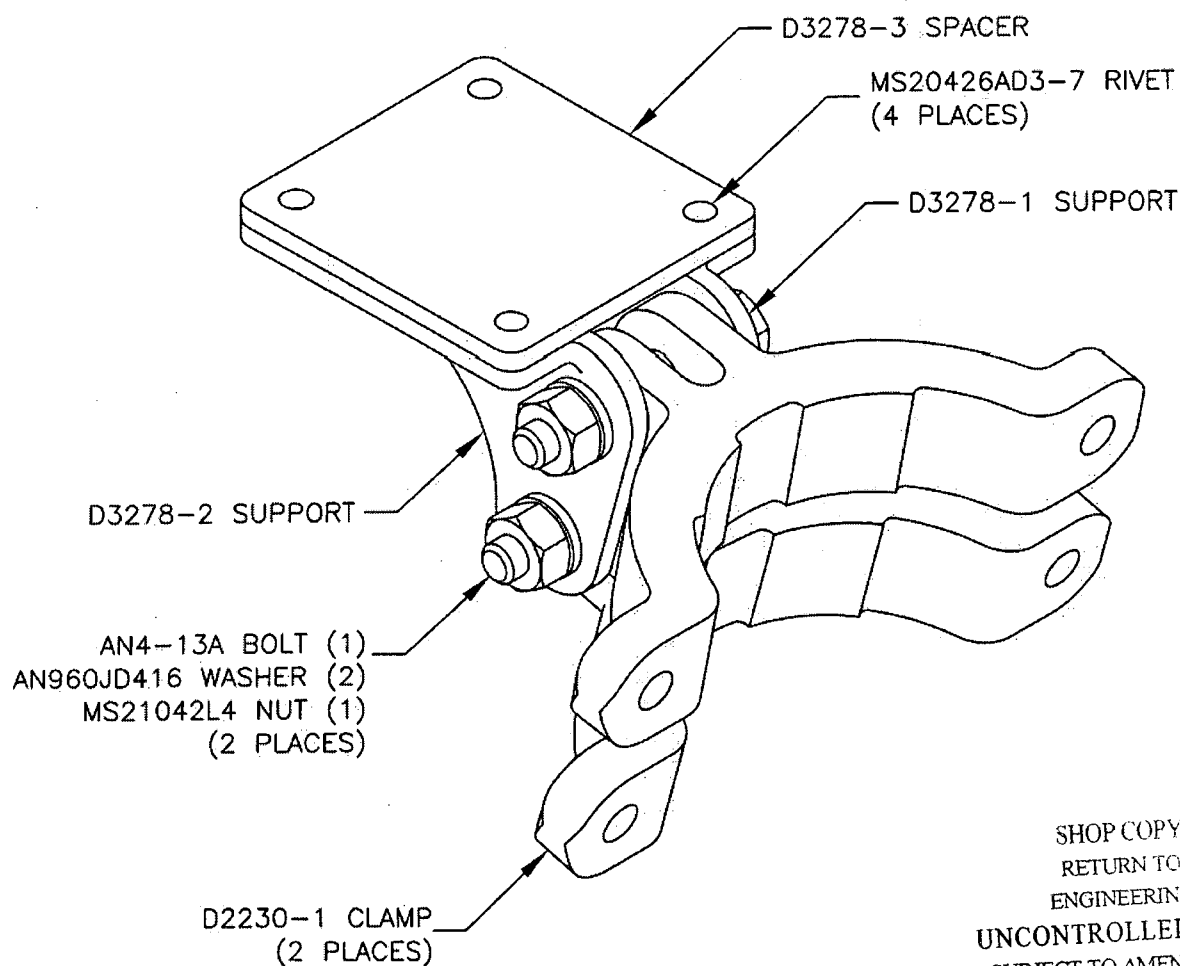
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	

DART

DESIGN CP		DRAWN BY CP		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. D3278 REV. B SHEET 1 OF 3	
DATE 05.03.31			TITLE SUPPORT ASSEMBLY SCALE NTS		
A	04.03.03		NEW ISSUE		
B	05.03.31		CHANGE DIM/TOL TO ENSURE FIT		

RELEASED
05.04.04 *[Signature]*

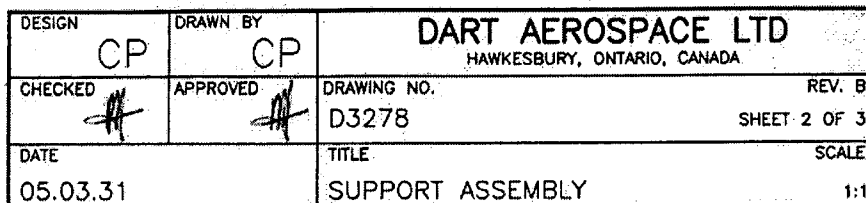
D3278-041 SUPPORT ASSEMBLY



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NO. 30150B

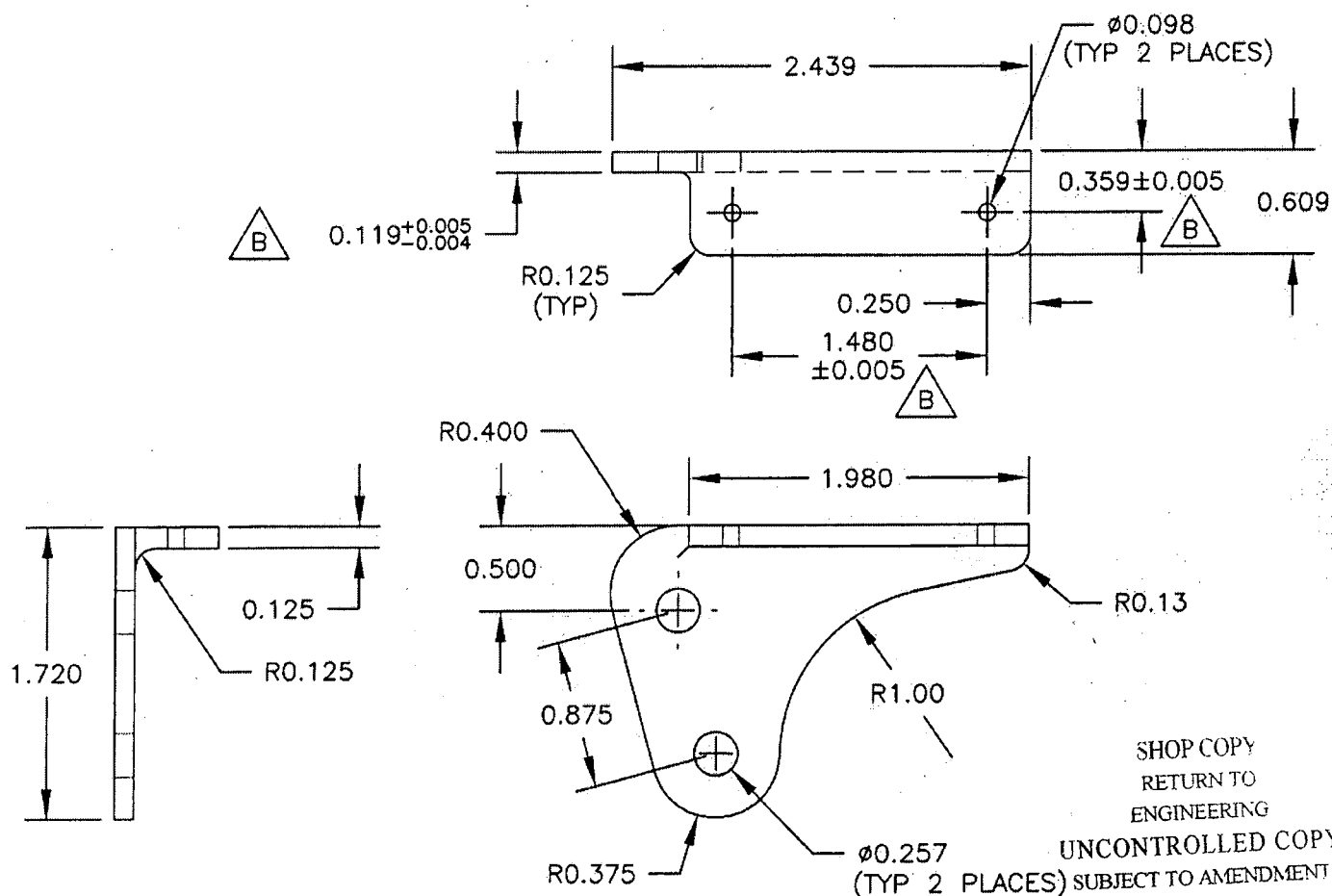
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RELEASED

05.04.04



D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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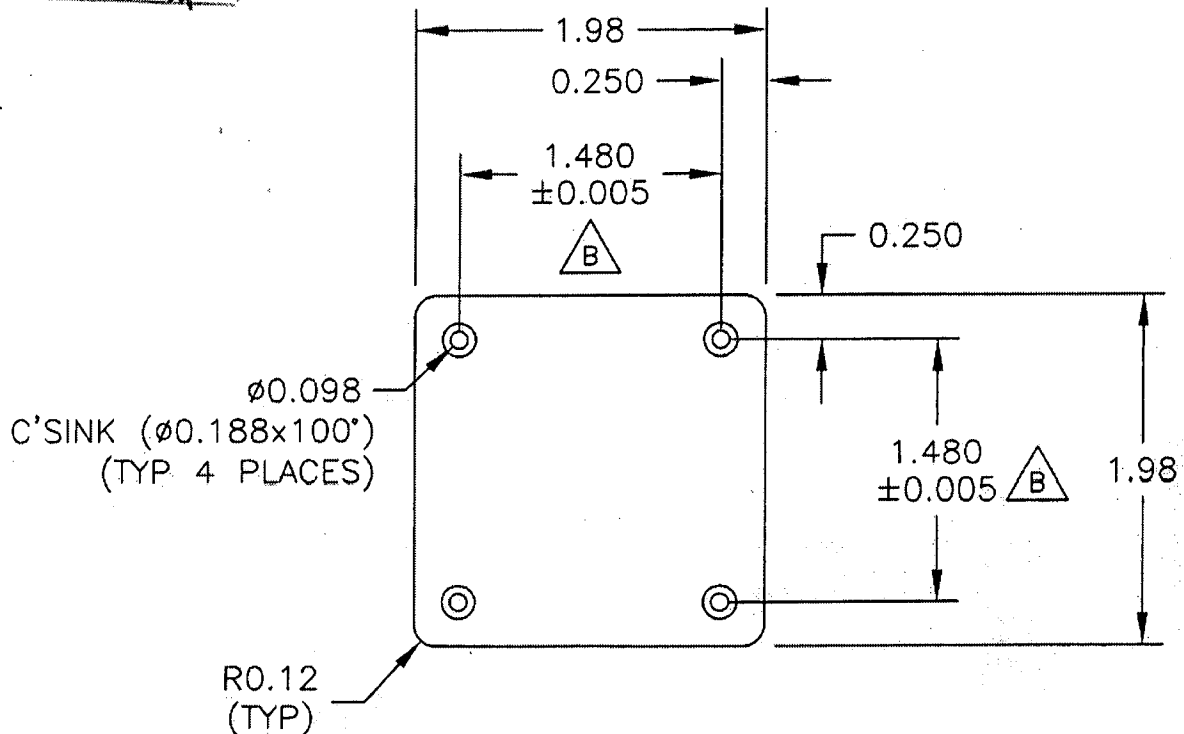
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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. B SHEET 3 OF 3
DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED

05.04.04 *[Signature]*

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WORK ORDER
NO. 30150B

D3278-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-S
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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